

CLASIFICARE / STANDARDS

AWS A5.22-95 : ER 309LT1 -4/1
 EN 12073 : T 23 12 MM 1

AUTORIZARI / APPROVALS

TUV
 CONTROLAS
 DNV
 LRS
 BV

CARACTERISTICI PRINCIPALE

Sarma tubulara inoxidabila pentru sudarea FCAW a otelurilor inoxidabile austenitice de componitie chimica similara si a imbinarilor eterogene dintre otelurile inoxidabile si otelurile carbon. Se utilizeaza cu protectie de amestec de gaze Ar/CO₂ sau CO₂. Caracterizata printr-o foarte buna sudabilitate, desprinderea usoara a zgorii si un bun aspect al cordonului. Recomandata pentru toate pozitiile, inclusiv vertical descendant.

MAIN FEATURES

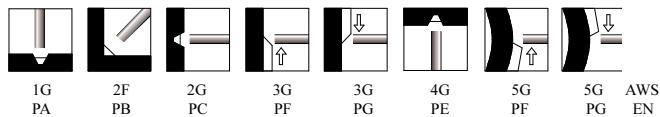
Inox flux cored wire for welding of stainless steels of similar composition and for heterogeneous joint between stainless steels and carbon steels. Shielding gas : mix Ar/CO₂ or CO₂. Good weldability, easy slag removal, good bead appearance. Suitable for all position vertical down too.

DOMENII DE APlicatie

Industria chimica si petrochimica
 Constructii navale

MAIN APPLICATIONS

Chemical and petrochemical
 shipbuilding

POZITII DE SUDARE / WELDING POSITIONS

CURENT / CURRENT : DC+
GAZ/GAS : MIX (Ar / CO₂) (M21-EN439) / CO₂

ANALIZA CHIMICA A METALULUI DEPUS %(Valori tipice) / ALL - WELD METAL CHEMICAL ANALYSIS % (Typical values)

GAZ/GAS	C	Mn	Si	Cr	Ni	Mo			
MIX	0.03	1.60	0.70	24.00	13.00	0.50			

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ/GAS	Trat. termic/Heat treatment	Rm N/mm ²	Rp 0,2 N/mm ²	E % 5d	Kv J 0°C	
MIX	Stare sudata/As welded	610	430	≥ 30	≥ 35	

AMBALARE / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/ Weight(Kg)	Diametru mm/Diameter mm				
				1.2		
K 300	15 Kg			2651312		